

Work Order ID 129597

February-18-15 1:23:31 PM

129597

~~PRELIMINARY ISSUE~~

Page 1

Item ID: D5222-1

Accept

N900040100

Setup Start

NS1

Revision ID: ~~PRELIM~~

Item Name: Wearplate

Stop

NS2

Start Date: 2/18/15

Start Qty: 8.00

8

Cust Item ID:

Required Date: 3/06/15

Req'd Qty: 8.00

8

Customer:

Reference:

Approvals:

Process Plan: W

Date: _____

Tooling: _____

Date: _____

Run

Start

NR1

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D5222

A

per ECN 15-529 W

100

0.00

100

FLOW WATER JET

8

Ø

Jm 15-2-19

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg

Dwg Rev: A

Prog Rev: A

2-Deburr if necessary

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.00

Quality Control

8

Ø

Jm 15-2-19

Work Order ID 129597

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Item ID: D5222-1 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: PRELIM Stop ***NS2***
 Item Name: Wearplate
 Start Date: 2/18/15 Start Qty: 8.00 ***8*** Cust Item ID:
 Required Date: 3/06/15 Req'd Qty: 8.00 ***8*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 *120* QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00				<u>8</u>			DAS 38 9-89 FEB 20 2015
140 *140* Packaging Packaging	Identify as per dwg & Stock Location: <u>WALD PRELIM</u> Memo	0.00 0.00				DAS 9 9-89	150224		
150 *150* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00						15/2/24	

POSITIVE RECALL
 EFFECTIVE
 RELEASED

AUTH

DATE

per ECU 1557

Picklist Print

Page 1

February-18-15 1:23:30 PM

Work Order ID: 129597

129597

Parent Item: D5222-1

D5222-1

Parent Item Name: Wearplate

Start Date: 2/18/15

Required Date: 3/06/15

Start Qty: 8.00

Required Qty: 8.00

Comments: IPP REV:A 15.02.18 NEW ISSUE DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M304S16GA

Purchased

No

sf

561.1042

2

M304S16GA

Jm15.2.19

304/316 Sheet .063

Location

Loc Qty

Loc Code

MAT019

561.1042

m131384

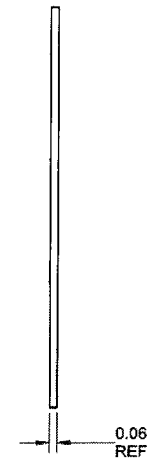
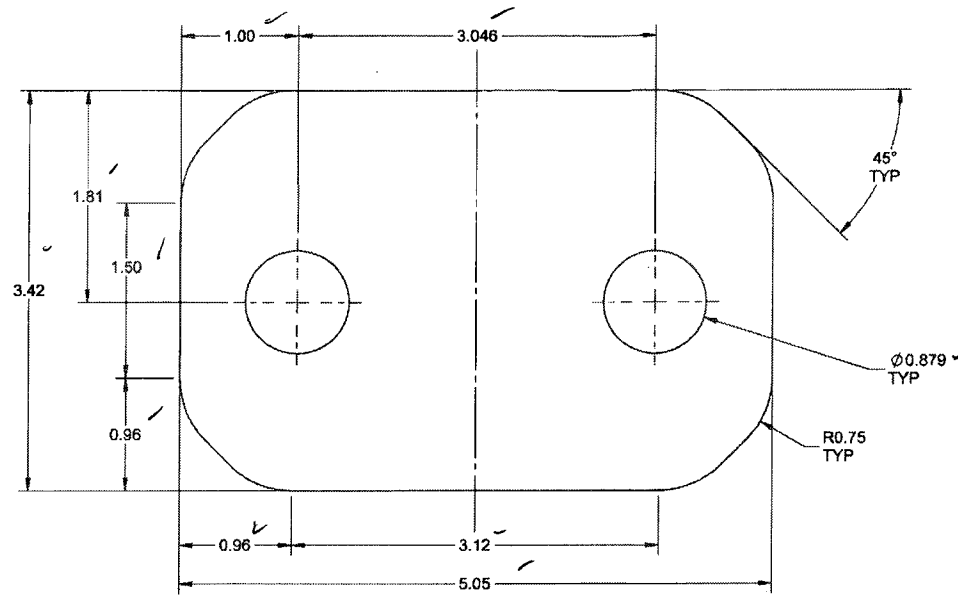
241.1042

m131503

320

131384

13



D5222-1 R22 WEARPLATE

WLB 129597

- NOTES:**
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET ANNEALED 2B FINISH, 16 GAUGE (0.063 THICK)
PER AMS 5513 (304) OR 5524 (316) OR ASTM A240 OR ASME SA240
REF DART SPEC M304S16GA
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 0.27 lbs

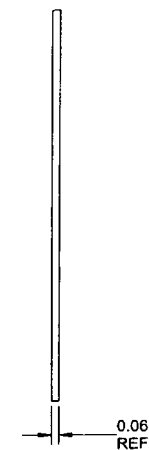
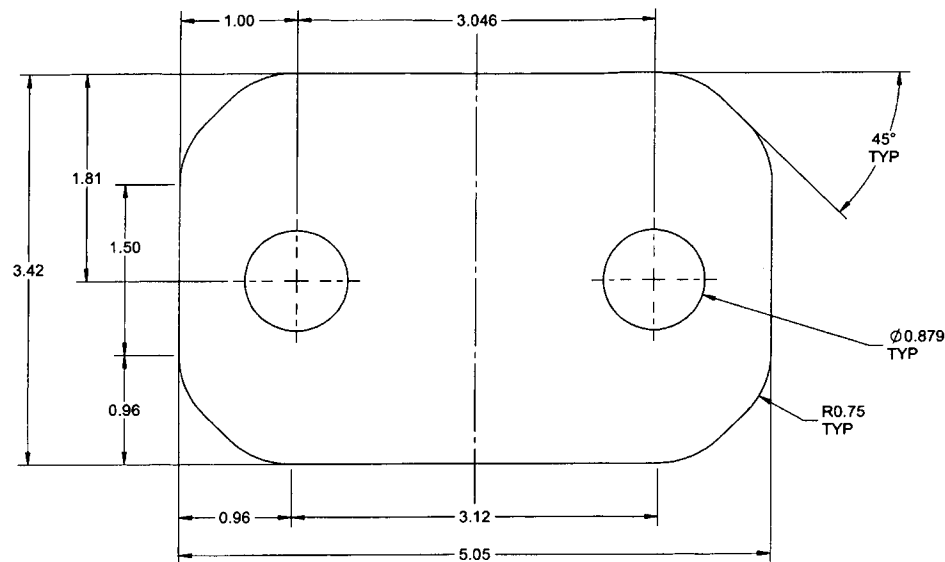
APPROVED

DESIGN	VS	DART AEROSPACE LTD	
DRAWN	VS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	RF	DRAWING NO.	REV. A
MFG. APPR.	DD	D5222	SHEET 3 OF 3
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	WEARPLATE	NTS
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DART AEROSPACE LTD	Work Order:	129597
Description: wear plate	Part Number:	05222-1
Inspection Dwg: 05222 Rev: A		Page 1 of 1

[illegible]

Engineering Approval: (If necessary)		Date:	
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D5222-1 R22 WEARPLATE

RELEASED

2015 FEB 23 *qp*

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET ANNEALED 2B FINISH, 16 GAUGE (0.063 THICK)
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APPROVED

DESIGN	VS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	VS		
CHECKED	RF	DRAWING NO.	REV. A
MFG. APPR.	DD	D5222	SHEET 3 OF 3
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	WEARPLATE	NTS
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